Work Order ID 110397-2 SPLIT *110397* Page 1

December-18-13 8:50:52 AM

Item ID: D4635-4 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Aft Ceiling Panel, RH

Start Date: 12/18/13 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 12/31/13 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 13-12-18 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4635	**Revision Nbr** E PDI PEI DK	DAS 27 9-89 Rev E per ECN 14.504 M							
100	HAND FINISHING THERMOFORMING	0.00							
100 Thermoform	**Memo** Cut Blanks	0.00				x2			DK 13/12/18
Thermoforming Machine									
105	Dry Material	0.00							
105 HandThermo	**Memo** Dry Sheet as per QSI022 KYDEX	0.00				x2			DK 13/12/18
Hand Finishing Thermoforming	Temp: 345°F								
	Time IN: 7:30 AM	12/12/13							
	Time OUT: 2:00 PM	12/12/18							

Item ID: D4635-4 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft Ceiling Panel, RH

Start Date: 12/18/13 **Start Qty:** 2.00 *2*
Required Date: 12/31/13 **Req'd Qty:** 2.00 *2*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
110	THERMOFORMING MACHINE					X1			DL 13/12/18
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4535-4 and Folio FTA150								
	Dwg. Rev. -01								
	Folio Rev. D								
	Visually inspect for proper formation and texture								
130		0.00				X1		BB 14/01/11	
130	HAND FINISHING THERMOFORMING					X1		BB 13/12/22	
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						Y1			DL 13/12/22
QC	**Memo**	0.00							
Quality Control									

NA DAS 27 9-89 14/1/16

Item ID: D4635-4 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Aft Ceiling Panel, RH
Start Date: 12/18/13 **Start Qty:** 2.00 *2* **Cust Item ID:**
Required Date: 12/31/13 **Req'd Qty:** 2.00 *2* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00	DAS 27 ~~9-89~~						
150 QC Quality Control	Memo	0.00	DAS 27 9-89			1 Agreed as per Rev, PDI PEI			
160	Packaging	0.00							
160 Packaging Packaging	Memo	0.00	USE ON W/O 111219			(1)	SAD	14/01/16	
170	QC21- Final Inspection - Work Order Release	0.00							
170 QC Quality Control	Memo	0.00							

RD4397A

CL 3.12.23 MCO 14-01-23 MF 14-1-16

POSITIVE RECALL
EFFECTIVE 3.12.8 AUTH
REJECTED DATE
DAS 27 9-89

Release Dwg Rev E

Picklist Print

December-18-13 8:50:56 AM

Work Order ID: 110397 *1110397*

Parent Item: D4635-4 *D4635-4*

Parent Item Name: Aft Ceiling Panel, RH

Start Date: 12/18/13 **Required Date:** 12/31/13

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 12/11/08 DL IPP Rev C Dwg. Update 13/07/09 DL IPP Rev. D Dwg, Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F5006-07		Purchased	No			100	sf	1,838.000	9.39	19	19	13/12/23	
MLEXS.093-F6006-07									**				

GE PLASTICS LEXAN SHEET

Location	Loc Qty	Loc Code
MAT023	2067.26	
114459	229.26	
123105	38	
124501	1800	

DART AEROSPACE LTD	Work Order:	110357
Description:	Part Number:	04635-4
Inspection Dwg: 04635 Rev: PDI		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than N/A "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	DK.	Date:	14/01/15

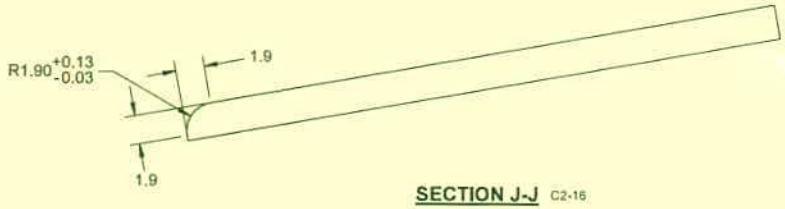
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.1"		40.1"	✓			
15.46"		15.46"	✓			
~~3.50~~"		3.53"	✓			
Ø 2.03"		2.01"	✓			
Ø 0.191"		0.191"	✓			
Ø 0.196"		0.196"	✓			
1.61"		1.55"	✓			
Ø30 ~~Ø.380~~"	MIN	~~Ø.38~~	✓			
0.35" - 0.40"		Ø.36"	✓			

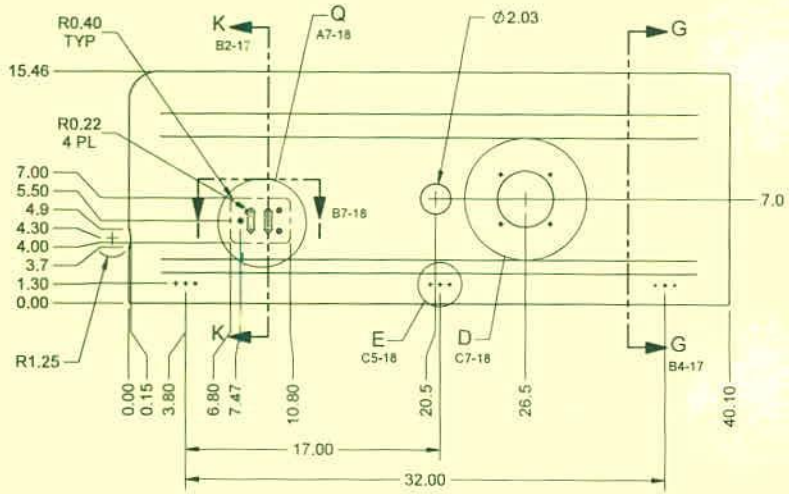
Measured by:	DAS 27 9.89 DK.	Date:	14/01
Audited by:		Date:	14/1/23
Preliminary Approval:		Date:	

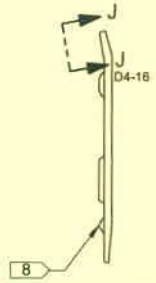
Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



SECTION J-J C2-16





D4635-4 RH, AFT CEILING PANEL

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-4 PER TOOL DT9842
10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1 SHEET 16 OF 15
MFG. APPR.		
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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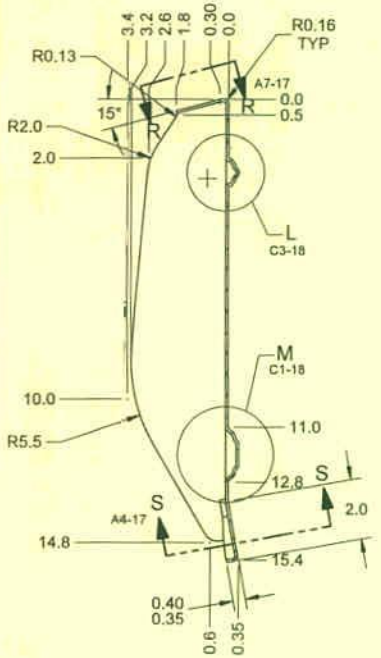

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SECTION A'-A' OPPOSITE B3-13 B3-14
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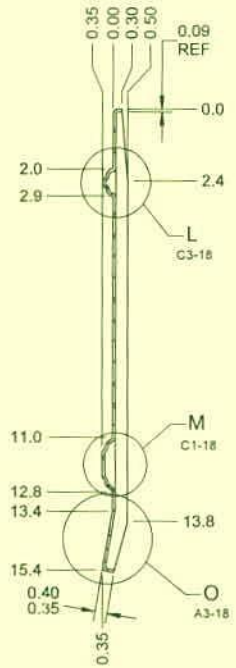

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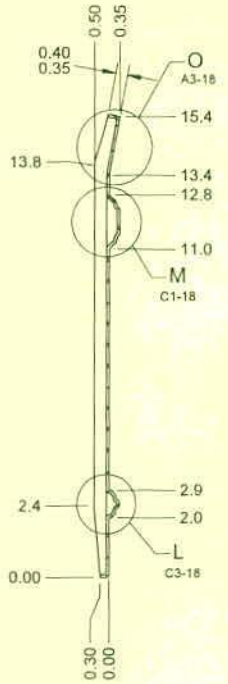

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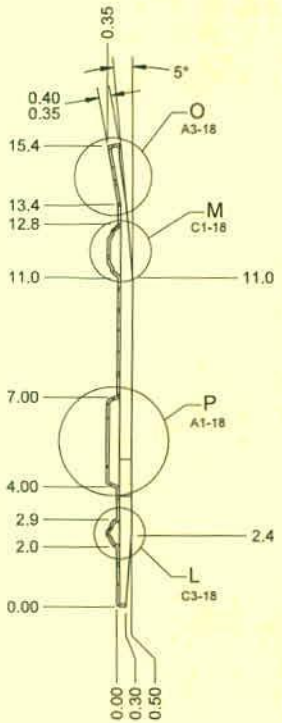

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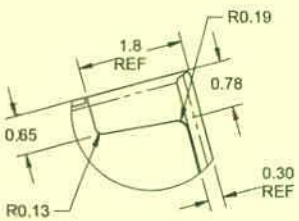

AUXILIARY VIEW R-R
SECTION R'-R' OPPOSITE D7-17
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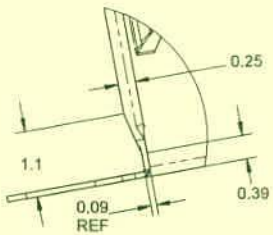

AUXILIARY VIEW S-S
SECTION S'-S' OPPOSITE B7-17
SCALE 2X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO. D4635	REV. PE1
MFG. APPR.			SHEET 17 OF 18
APPROVED		TITLE OUTBOARD CEILING PANELS	SCALE NTS
DE APPR.			
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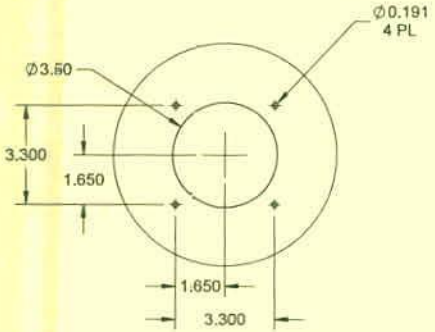

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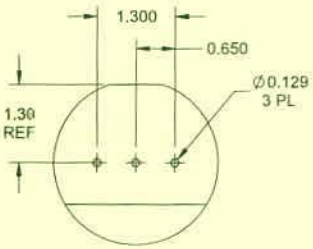

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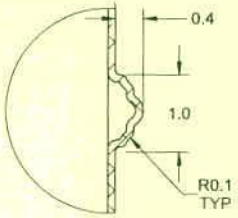
SCALE 4X



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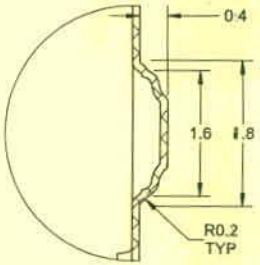

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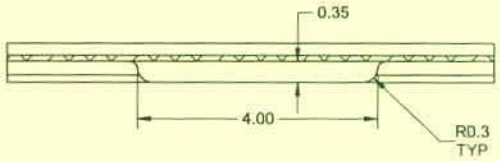

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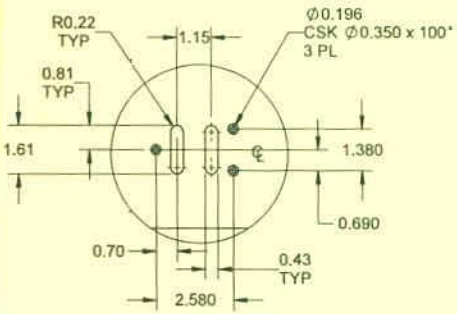

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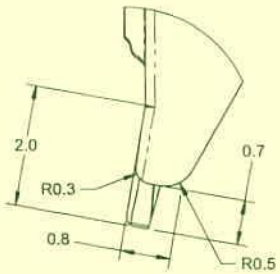

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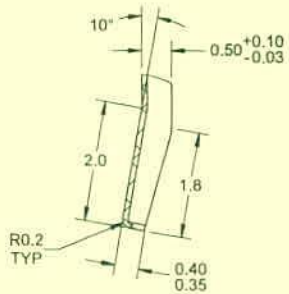

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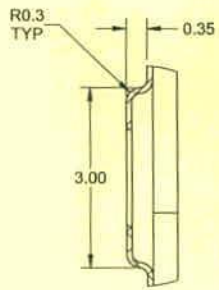

DETAIL P C2-17
SCALE 4X

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4635 REV. PE1 SHEET 18 OF 18
MFG. APPR.		
APPROVED		TITLE OUTBOARD CEILING PANELS SCALE NTS
DE APPR.		
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DART AEROSPACE LTD

DART AEROSPACE

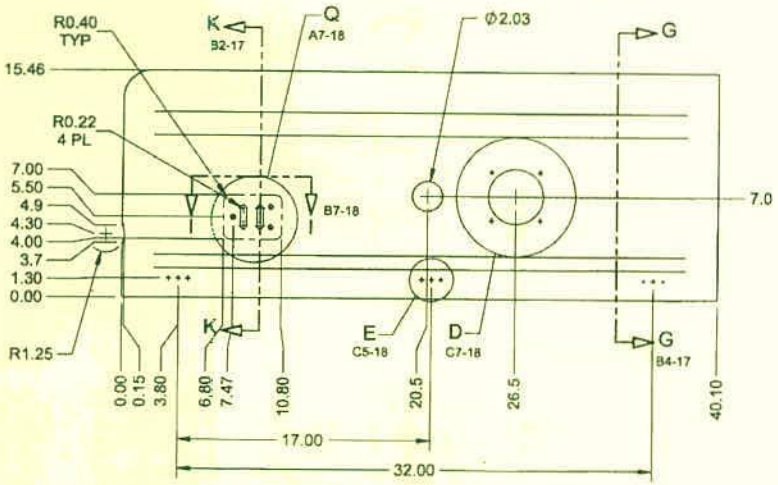
Description:	aft Ceiling Panel RH	Work Order:	H110397
Inspection Drawing:	~~RB~~ D4635	Rev: PE	Part Number: D4635-4

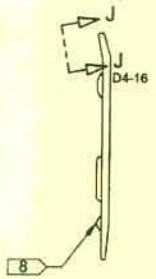
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.00	+/-0.05	32.90	✓		T	
17.00	"	17.00	✓		T	QC1-13
20.5	"	20.5	✓		T	"
26.5	"	26.51	✓		T	"
Ø2.05	"	2.04	✓		T	"
1.30	"	1.30	✓		T	QC1-07
7.00	"	7.00	✓		T	"
15.46	"	15.46	✓		T	QC1-13
1.9	"	1.9	✓		T	"
40.10	"	40.10	✓		T	"
20	"	20	✓		T	QC1-07
29	"	29.1	✓		T	
11.00	"	11.00	✓		T	
12.8	"	12.81	✓		T	
13.4	"	13.40	✓		T	
15.40	"	15.40	✓		T	
0.35/0.40	"	0.356	✓		T	
0.30	"	0.301	✓		T	
0.50	"	0.524	✓		T	
2.40	"	2.42	✓		T	
13.8	"	13.99	✓		T	
			✓			
			✓			
			✓			

Measured by: ~~DAS~~ 27 9-89	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date 14/1/16	Date	Date	Date

SECTION J-J C2-16

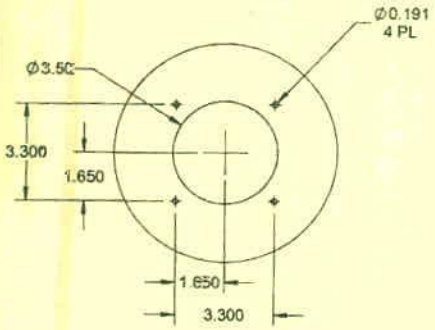




D4635-4 RH, AFT CEILING PANEL

NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 2.66 lbs
8) TEXTURE ON THIS SIDE
9) TRIM D4635-4 PER TOOL DT9842
10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. REV. E
MFG. APPR.		D4635 SHEET 16 OF 16
APPROVED		TITLE SCALE
DE APPR.		OUTBOARD CEILING PANELS NTS
DATE	14.01.09	COPYRIGHT © 2012 BY DART AEROSPACE LTD



DETAIL D B4-13 B3-14 B5-15 B5-16
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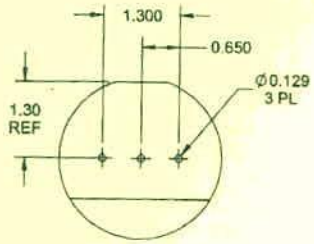
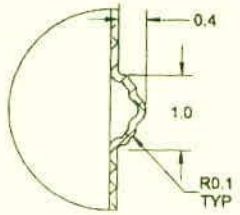


DETAIL E C7-13 B6-14 C6-15 B5-16
SCALE 4X



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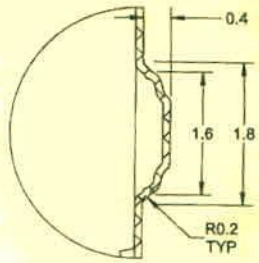

DETAIL M C2-17 C3-17 C5-17 C7-17
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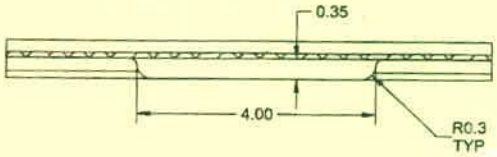
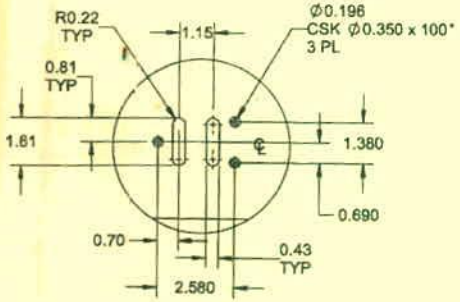


SECTION I-I B5-16
SCALE 4X



DETAIL Q C5-16
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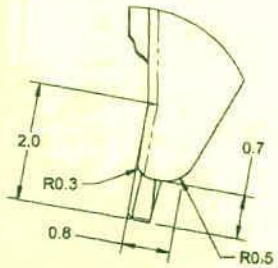

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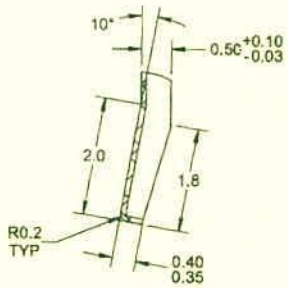

DETAIL O D2-17 D3-17 B5-17
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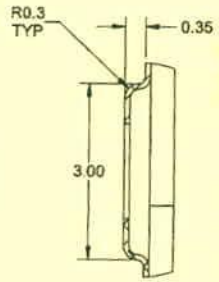

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DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	DRAWING NO. D4635 REV. E
CHECKED	DC	SHEET 18 OF 18
MFG. APPR.		TITLE OUTBOARD CEILING PANELS SCALE NTS
APPROVED		
DE APPR.		
DATE	14.01.09	

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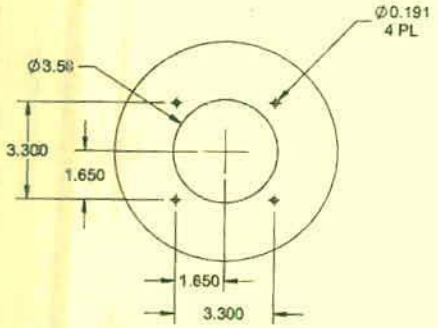

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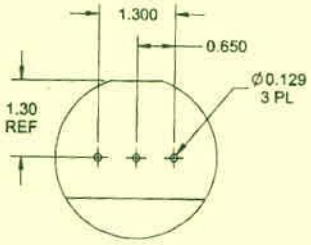

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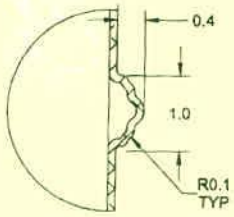

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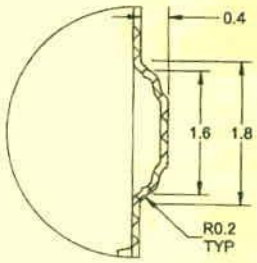

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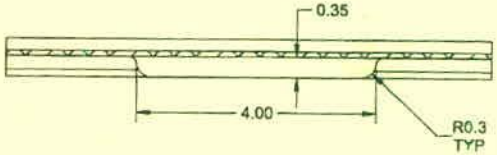

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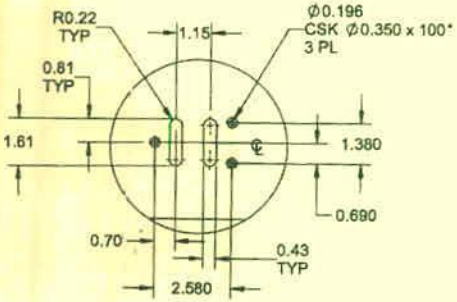

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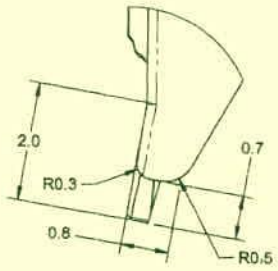

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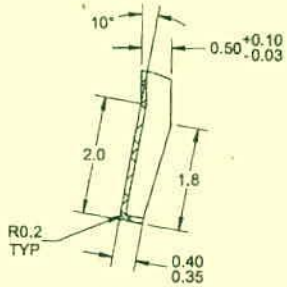

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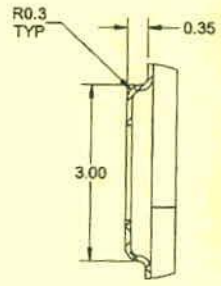

DETAIL P C2-17
SCALE 4X

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